



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2572
Job Sheet 213868



Part No: D2572

Job Qty: 12 pcs

Part Name: Saddle, Fwd, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/8/20

Job Tracking No:

Due Date: 11/4/20

Created By: Jennifer Renwick

Type: Stock

Description: SIOP

Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
90	Machining - Issue SN	12 pcs	11/2/20		0.00	0.00	HAAS - 1		DAS 52	20/10/20
							HAAS - 2		9-89	
							HAAS - 3			
							HAAS - 4		DAS 52	
100	HAAS 4 Axis - B4B	12 pcs	11/3/20		1.00	19.35	HAAS - 1 - B4B		DAS 52	20/10/24
							HAAS - 2 - B4B		9-89	
							HAAS - 3 - B4B			
							HAAS - 4 - B4B		DAS 52	
110	Conventional Mill - 1 - B4B	12 pcs	11/3/20		0.00	1.92	Conventional Mill - 1 - B4B		DAS 52	20/10/24
							Conventional Mill - 2 - B4B		9-89	
120	QC 2	12 pcs	11/3/20		0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			



Container No: S307242



Part: D2572

Job No: 213868

Serial No/Batch: S307242

Material:

Qty:

Due Date:

Notes: Various STS

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartae.com
www.dartaerospace.com

					QC 2 - 50	
					QC 2 - 51	DAS
					QC 2 - 52	52
					QC 2 - 57	9-89 10/10/24
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
130 QC 8	12 pcs	11/3/20	0.00	0.00	QC 8 - 12	
					QC 8 - 14	9-89 10/10/24
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
140 Handfinish - 1-1 Chemical-B4B	12 pcs	11/3/20	0.00	1.25	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 -	

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				Packaging 3 - 3 - B4B ✓		DAS
				Packaging 3 - 4 - B4B	NOV 4 2020	80
				Packaging 3 - 5 - B4B	51398	9-89
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
				Packaging 3 - 37 - B4B	DAS	
180 QC 21 - SA	12 pcs	11/4/20	0.00 0.00	QC 21 - SA - 21	21	
				QC 21 - SA - 70	9-89	NOV 04 2020
				QC 21 - SA - 9		
				QC 21 - SA - 77		
				QC 21 - SA - 28		
Part Op 100 - (HAAS CNC vertical machine #1) Program Batch No. <u>830714</u> Double check by: <u>1-1</u> 1-Machine Step No 1 Descriptions: per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp 110 - (Manufacture as per dwg) Machine keyway as per dwg D2571 & D2572 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____ 160 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
D6101-005	Saddle Billet	12 pcs (1 ea)	90-Machining - Issue SN	<u>5306579 x 12</u>		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
90-Machining - Issue SN	D6101-005	12	6	0		

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Inboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Inboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Fwd Inboard	7.990Inches + 0.020 - 0.000	8.010 7.990		
6	Saddle, Fwd Inboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
7	Saddle, Fwd Inboard	0.257Inches + 0.005 - 0.000	0.262 0.257		
8	Saddle, Fwd Inboard	0.375Inches + 0.005 - 0.000	0.380 0.375		
9	Saddle, Fwd Inboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
10	Saddle, Fwd Inboard	1.174Inches + 0.010 - 0.000	1.184 1.174		
11	Saddle, Fwd Inboard	0.558Inches + 0.020 - 0.000	0.578 0.558		
12	Saddle, Fwd Inboard	1.174Inches + 0.010 - 0.000	1.184 1.174		
13	Saddle, Fwd Inboard	1.490Inches + 0.010 - 0.000	1.500 1.490		
14	Saddle, Fwd Inboard	2.495Inches + 0.010 - 0.000	2.505 2.495		
15	Saddle, Fwd Inboard	3.869Inches + 0.010 - 0.000	3.879 3.869		
16	Saddle, Fwd Inboard	0.115Inches + 0.020 - 0.000	0.135 0.115		
17	Saddle, Fwd Inboard	0.115Inches + 0.020 - 0.000	0.135 0.115		
18	Saddle, Fwd Inboard	0.240Inches + 0.020 - 0.000	0.260 0.240		
19	Saddle, Fwd Inboard	0.115Inches + 0.020 - 0.000	0.135 0.115		
20	Saddle, Fwd Inboard	0.178Inches + 0.020 - 0.000	0.198 0.178		
21	Saddle, Fwd Inboard	2.940Inches + 0.040 - 0.000	2.980 2.940		
22	Saddle, Fwd Inboard	0.230Inches + 0.020 - 0.000	0.250 0.230		
23	Saddle, Fwd Inboard	0.115Inches + 0.020 - 0.000	0.135 0.115		
24	Saddle, Fwd Inboard	0.307Inches + 0.005 - 0.000	0.312 0.307		
25	Saddle, Fwd Inboard	0.760Inches + 0.005 - 0.000	0.765 0.760		
26	Saddle, Fwd Inboard	0.352Inches + 0.020 - 0.000	0.372 0.352		
27	Saddle, Fwd Inboard	0.470Inches + 0.060 - 0.000	0.530 0.470		
28	Saddle, Fwd Inboard	0.615Inches + 0.020 - 0.000	0.635 0.615		
29	Saddle, Fwd Inboard	0.053Inches + 0.020 - 0.000	0.073 0.053		
30	Saddle, Fwd Inboard	0.240Inches + 0.020 - 0.000	0.260 0.240		
31	Saddle, Fwd Inboard	1.375Inches + 0.020 - 0.000	1.395 1.375		
32	Saddle, Fwd Inboard	0.115Inches + 0.020	0.135		

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			- 0.000	0.115
33	Saddle, Fwd Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Fwd Inboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

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DART AEROSPACE LTD	Work Order: 213868
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.003	8.003	8.002		
F	0.490	0.510		0.492	0.499	0.500	0.498		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.378	0.378	0.378	0.378		
I	0.490	0.510		0.500	0.502	0.500	0.500		
J	1.174	1.184		1.178	1.179	1.178	1.178		
K	0.558	0.578		0.568	0.568	0.567	0.567		
L	1.174	1.184		1.179	1.179	1.179	1.178		
M	1.490	1.500		1.495	1.494	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.873	3.874	3.874		
P	0.115	0.135		0.130	0.130	0.130	0.130		
Q	0.115	0.135		0.126	0.126	0.125	0.125		
R	0.240	0.260		0.254	0.252	0.253	0.252		
S	0.115	0.135		0.126	0.128	0.129	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.244	0.243	0.244	0.244		
W	0.115	0.135		0.134	0.131	0.131	0.130		
X	0.307	0.312		0.310	0.310	0.310	0.3115		
Y	0.760	0.765		0.762	0.762	0.762	0.762		
Z	0.352	0.372		0.368	0.366	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.619	0.622	0.621	0.621		
AC	0.053	0.073		0.060	0.060	0.058	0.058		
AD	0.240	0.260		0.254	0.252	0.252	0.252		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.248	0.248	0.248	0.248		
AH	0.240	0.260		0.253	0.252	0.251	0.251		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 20-10-22	Date: 20/10/24

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	213868
Description: Saddle, Fwd Inboard		Part Number:	D2572
Inspection Dwg: D2572 Rev. F		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.498	0.497	0.497	0.501		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.378	0.378	0.379	0.379		
I	0.490	0.510		0.501	0.499	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.567	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.496	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.130	0.130	0.130	0.128		
Q	0.115	0.135		0.125	0.125	0.125	0.125		
R	0.240	0.260		0.252	0.252	0.252	0.252		
S	0.115	0.135		0.130	0.132	0.132	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.980	2.960	2.960	2.960		
V	0.230	0.250		0.242	0.242	0.242	0.243		
W	0.115	0.135		0.131	0.131	0.131	0.132		
X	0.307	0.312		0.312	0.312	0.311	0.312		
Y	0.760	0.765		0.762	0.762	0.762	0.762		
Z	0.352	0.372		0.363	0.362	0.3615	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.622	0.622	0.623		
AC	0.053	0.073		0.060	0.060	0.060	0.060		
AD	0.240	0.260		0.251	0.250	0.250	0.251		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.248	0.248	0.248	0.250		
AH	0.240	0.260		0.250	0.246	0.245	0.246		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

PAS

Measured by:	DIP
Date:	20-10-22 / 20/10/24

Audited by:	JK
Date:	20/10/24

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 213868
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

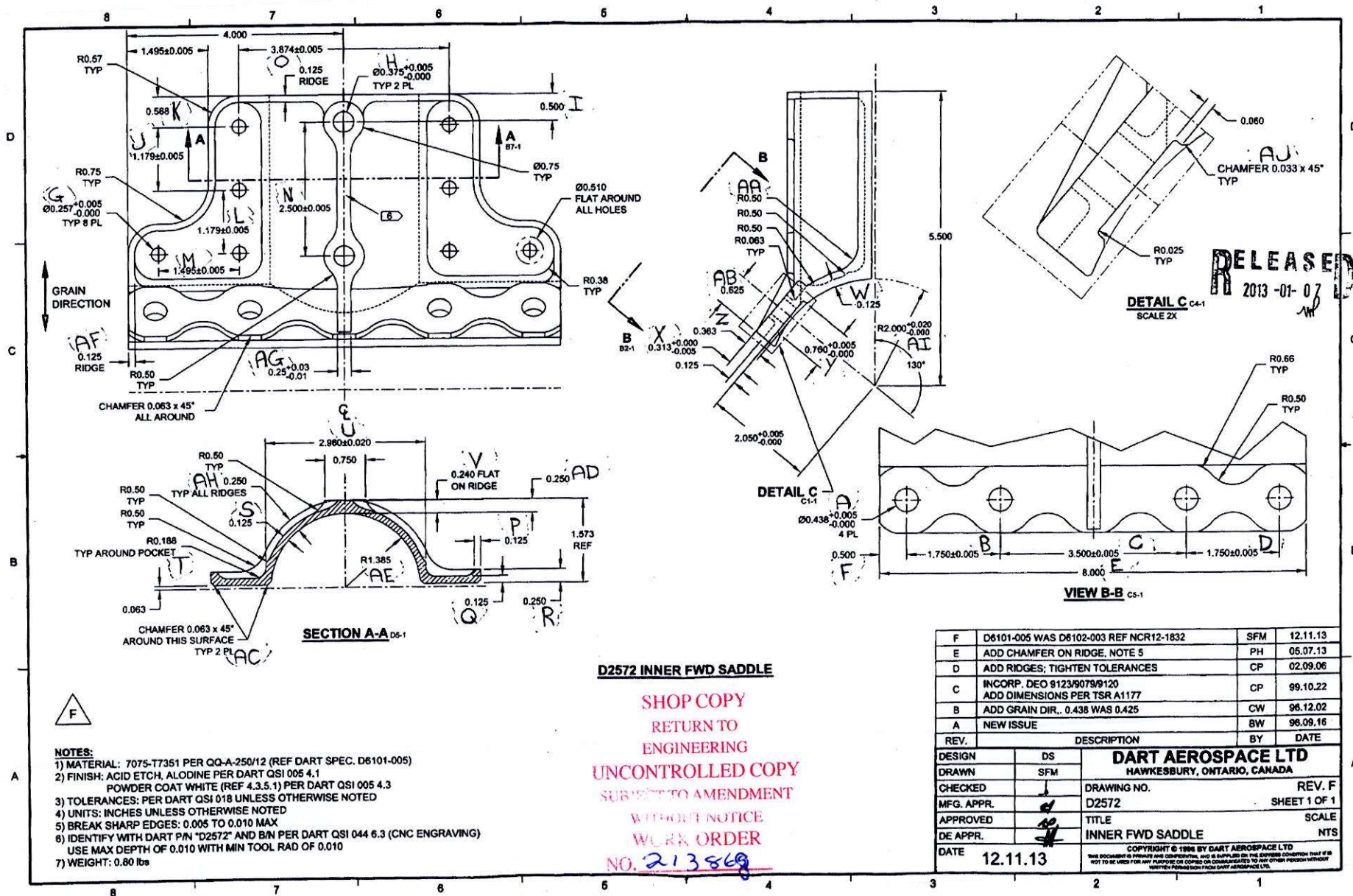
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9	10	11	12		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.498	0.497	0.498	0.498		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.379	0.379	0.379	0.379		
I	0.490	0.510		0.500	0.500	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.567	0.568	0.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.128	0.128	0.128	0.128		
Q	0.115	0.135		0.126	0.125	0.126	0.126		
R	0.240	0.260		0.252	0.251	0.252	0.253		
S	0.115	0.135		0.129	0.129	0.128	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.242	0.243	0.244	0.243		
W	0.115	0.135		0.132	0.132	0.131	0.131		
X	0.307	0.312		0.311	0.312	0.311	0.311		
Y	0.760	0.765		0.762	0.762	0.762	0.762		
Z	0.352	0.372		0.365	0.367	0.366	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.621	0.622	0.622	0.623		
AC	0.053	0.073		0.060	0.060	0.060	0.060		
AD	0.240	0.260		0.250	0.252	0.252	0.251		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.249	0.250	0.250	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

Measured by: <u>DTF</u>
Date: <u>20-10-22</u> / <u>9-89</u> <u>10/10/24</u>

Audited by: <u>mf</u>
Date: <u>20/10/24</u>

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	



Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					